

Date: Tuesday, 16/12/2008 2:13:17 PM
 User: Julie Dawson

Process Sheet

Split

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BAFFLE ASSEMBLY
Job Number	: 44125	Part Number	: D3276042
Estimate Number	: 11265	Drawing Number	: D3276 REV B
P.O. Number	:	Project Number	: N/A
This Issue	: 16/12/2008 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: 11 Type : SMALL /MED FAB	Due Date	: 30/12/2008
Previous Run	: 36597	Qty:	10 Um: Each
Written By	:		
Checked & Approved By	: <u>JLD 08-12-16</u>		
Comment	: Est Rev:A New Issue 05-12-06 JLM Est Rev:B Now on Waterjet 06-09-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S040	6061-T6 .040 Sheet
-----	-------------	--------------------



Comment: Qty.: 1.0715 sf(s)/Unit Total: 10.7153 sf(s)
 Material: 6061-T6 (QQ-A-250/11) 0.040" thick
 (M6061T6S.040)
 Batch: 109376 13 8-12-17

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3276
 Dwg Rev: B
 Prog Rev: B

13 8-12-17

(12)

2-Deburr if necessary 13 8-12-17

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

508/12/17 (42)

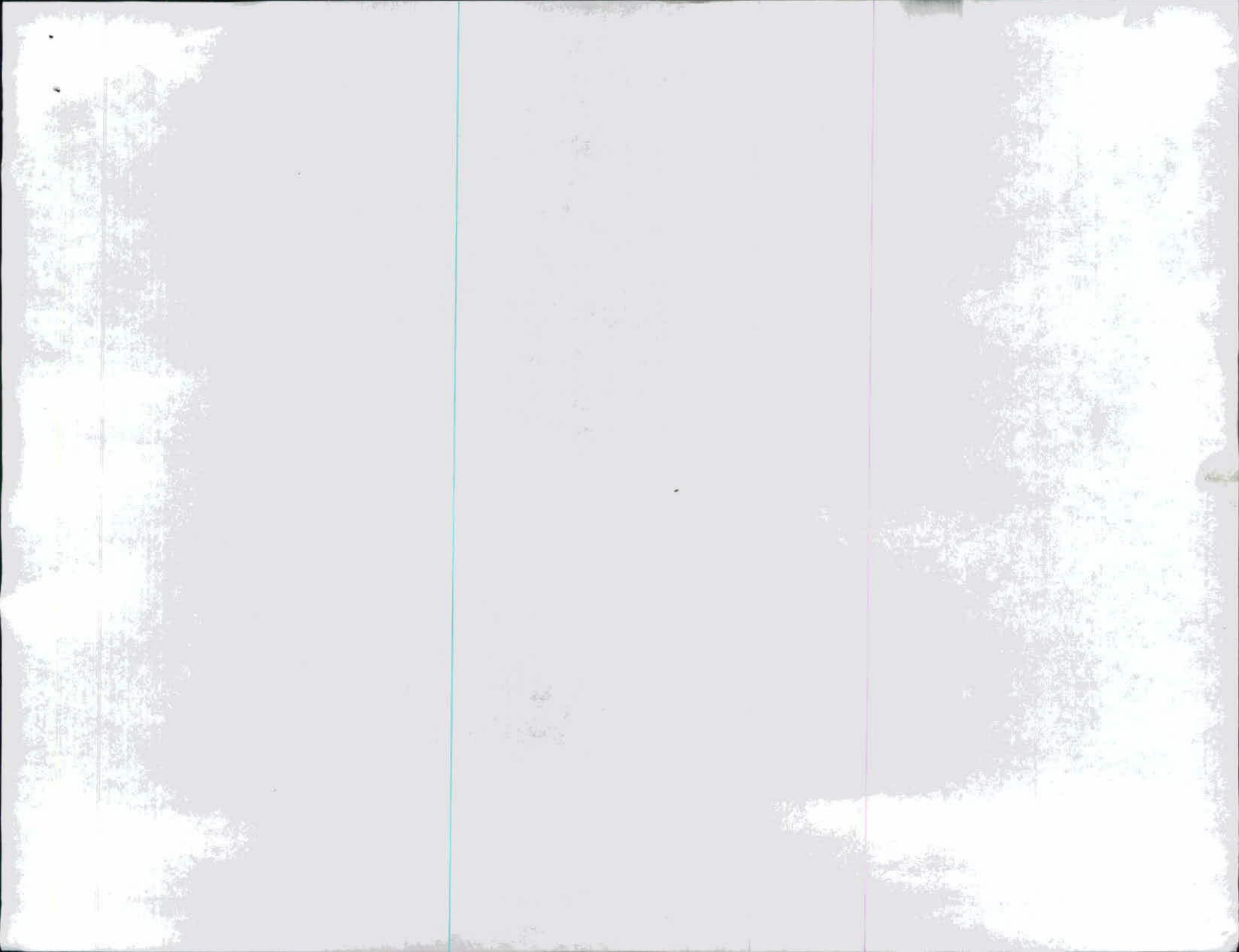
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

N/A S



Tuesday, 16/12/2008 2:13:17 PM
Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 44125

Part Number: D3276042

Job Number:



Seq. #:

Machine Or Operation:

Description:

2-Roll as per Dwg D3276

SB 08/12/18 ①

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3276

SB 08/12/18 ①

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/18 (x)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(1X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L 08/12/18

9.0

POWDER COATING

POWDER COATING



(1X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:50
320 OF
10:20

M-L 08/12/18

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



①

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fd 08/12/18

11.0

D2464

3/4 Seal



Comment: Qty.: 2.2500 f(s)/Unit Total: 22.5000 f(s)

Pick:

Qty Part Number

Description Batch

27.0" D2464

Neoprene Seal

B39669

ep 08/12/18

12.0

D32763

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3276-3

Decal

B36633

ep 08/12/18

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 44125

Part Number: D3276042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D3276

08/12/18 @

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/12/18 @

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: PPP-44115

08/12/18 (X1)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



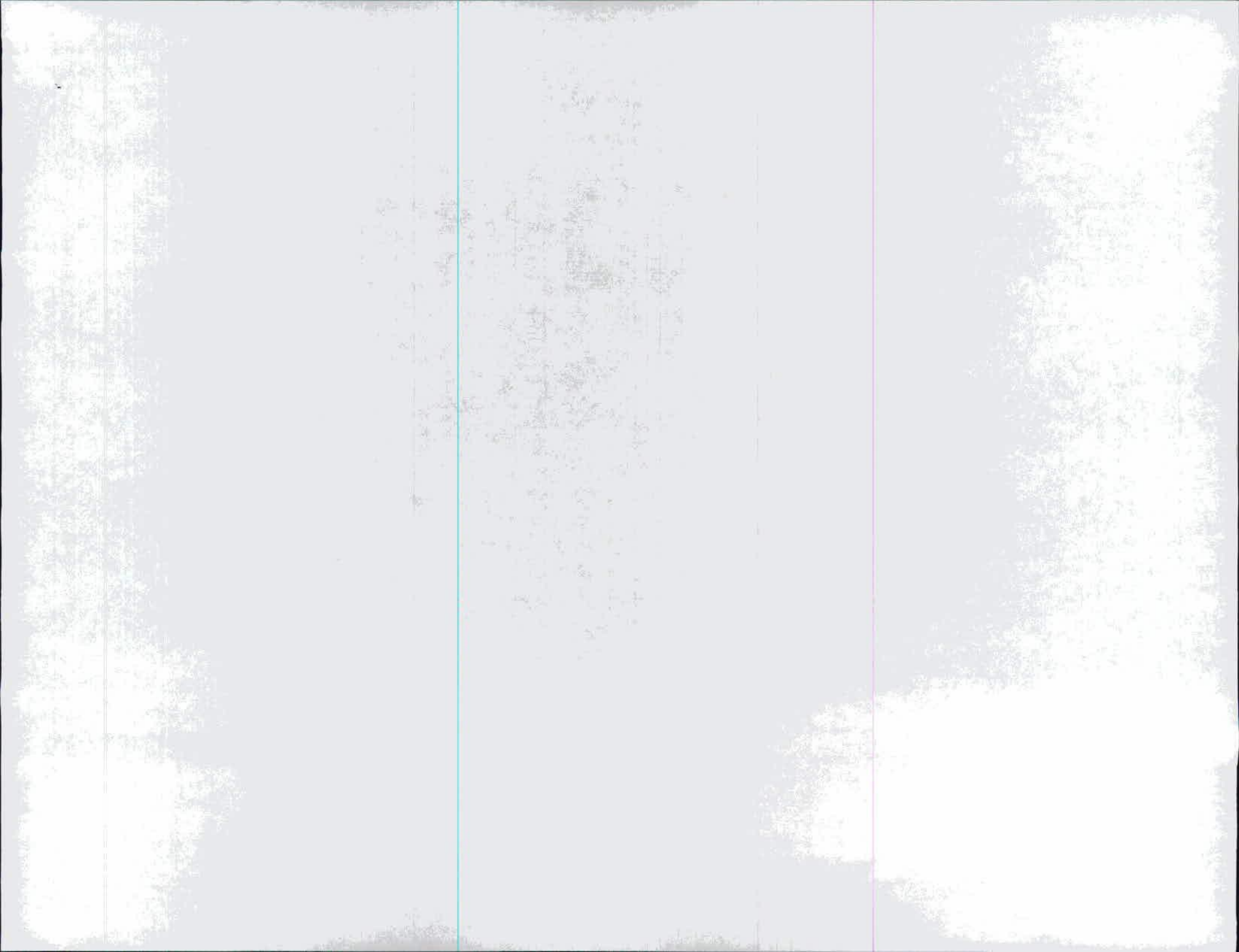
Comment: FINAL INSPECTION/W/O RELEASE

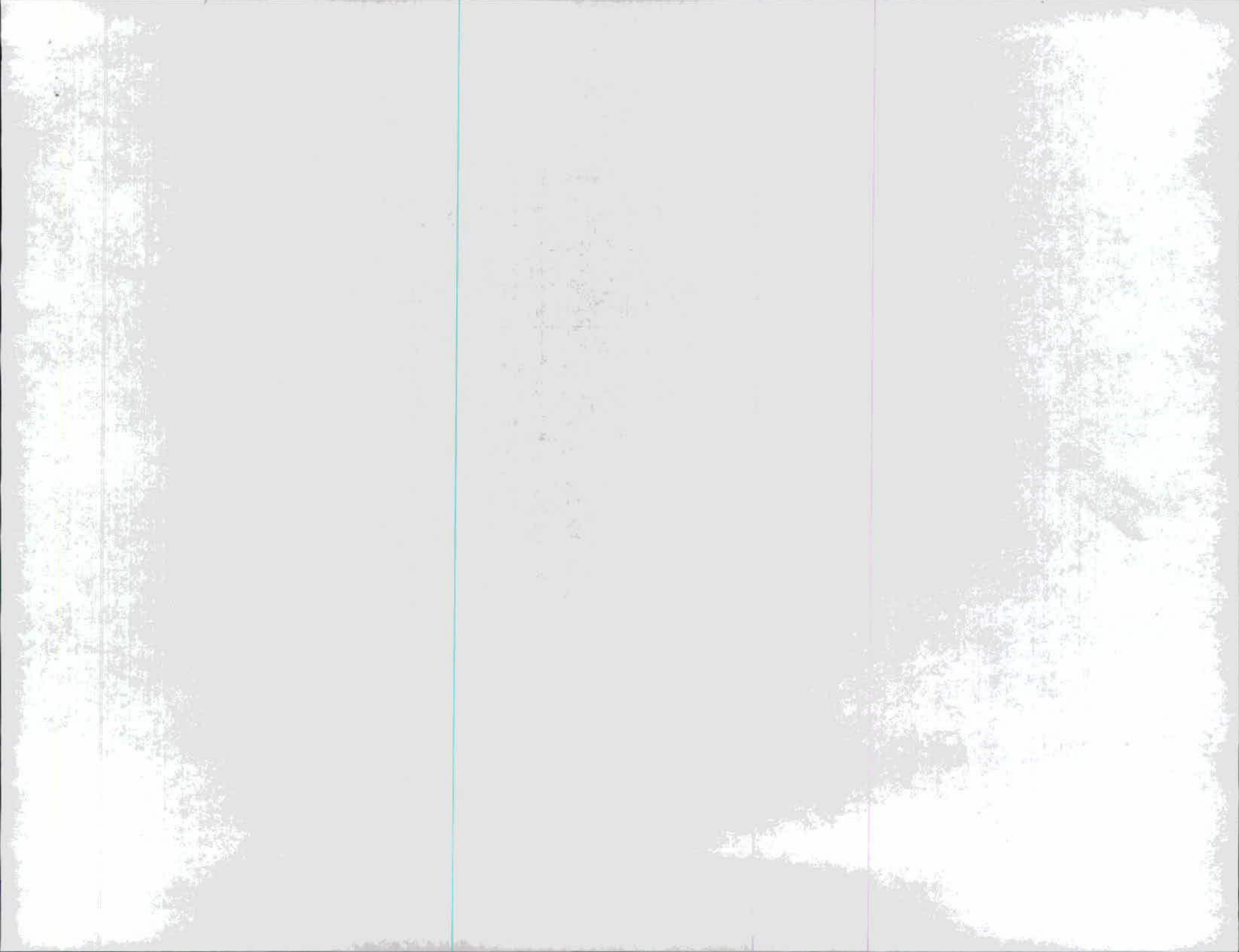
08/12/19

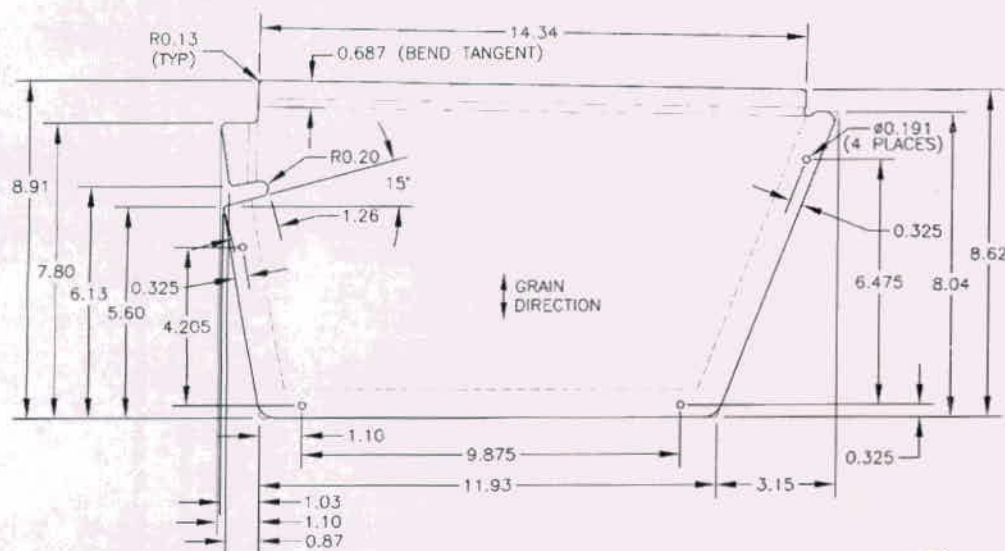
Job Completion



08/12/18

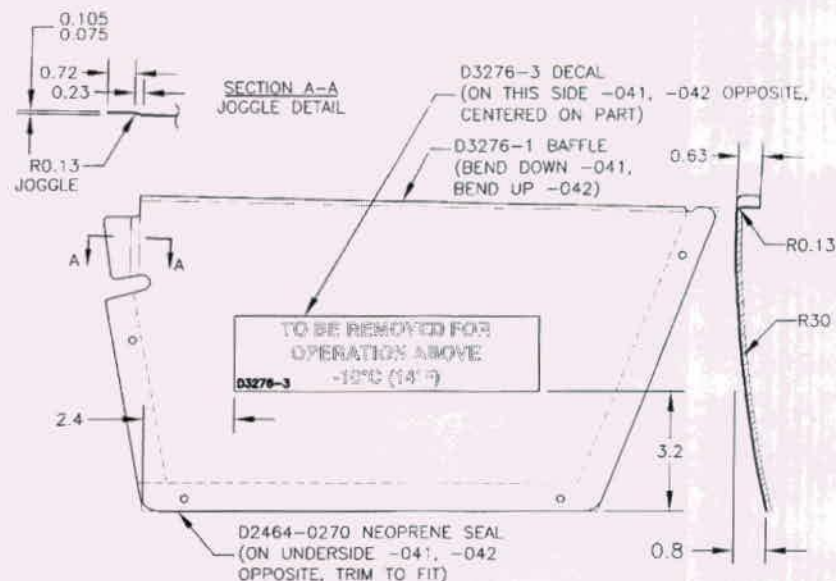






D3276-1 BAFFLE (FLAT PATTERN)

- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)
(REF DART SPEC, M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

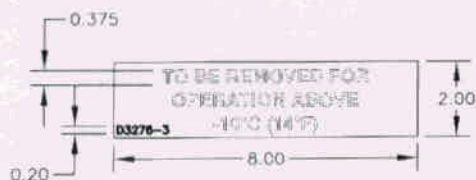


D3276-041 BAFFLE ASSEMBLY, LH (SHOWN)

D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)

REFERENCE ONLY

RELEASED
05.02.00



D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

COPYRIGHT © 2004 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

B	05.01.25	LABEL NOW -10°C; CURVE PART
A	05.01.07	NEW ISSUE
DESIGN	CP	DART DART AEROSPACE LTD. WARRICK, ONTARIO, CANADA
CHECKED	CP	DRAWING NO. D3276
DATE	05.01.25	TITLE BAFFLE ASSEMBLY
		REV. B SHEET 1 OF 1 SCALE 1:3

DECEMBER 1947